

## **SPECS:**

**Electrical – 120V 20A requires 5-20R for use. (Machine is equipped with a 5-20P (plug)).**

**Weight – 125 lbs.**

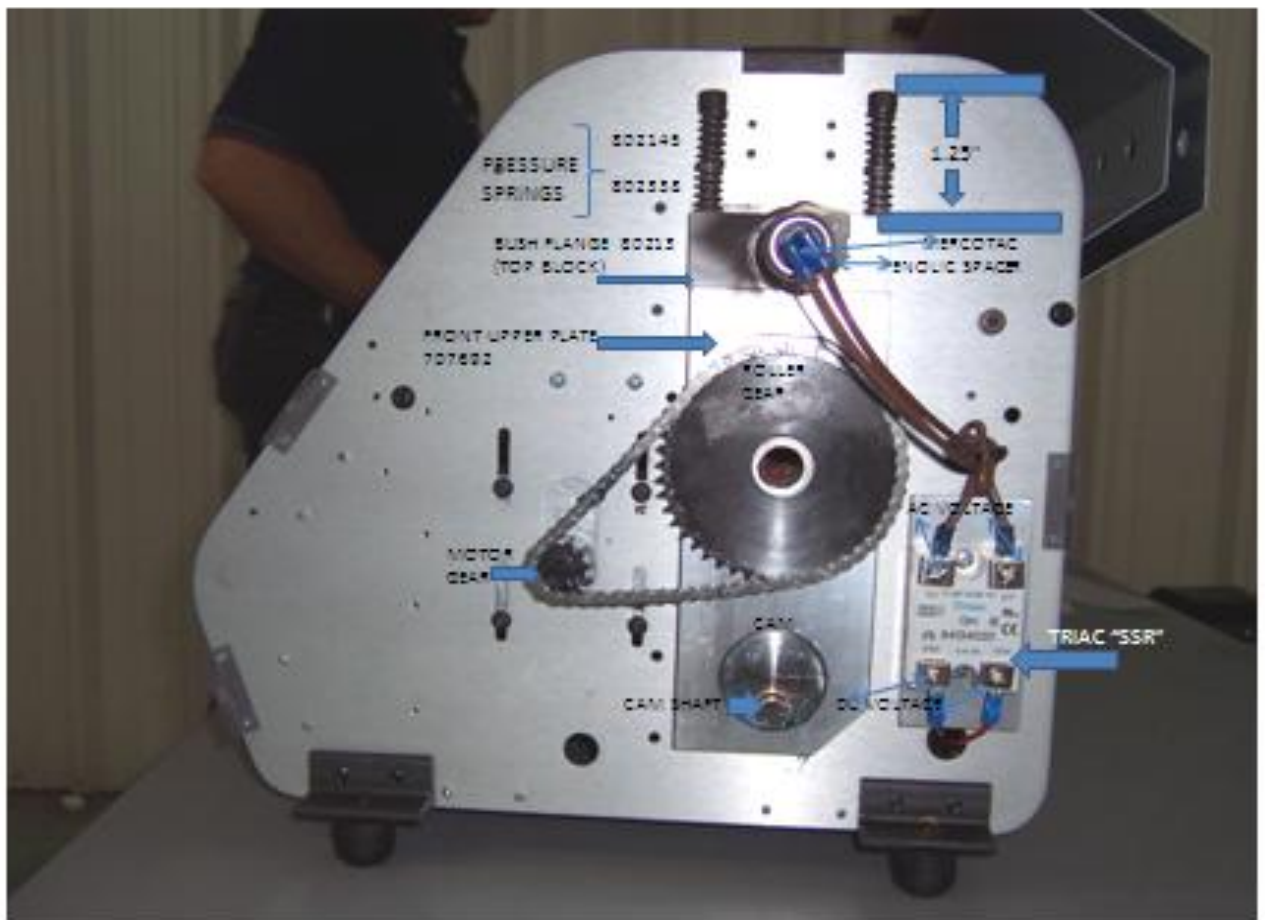
**Shipping Weight – 175 lbs.**

**Height – 15" (381 mm)**

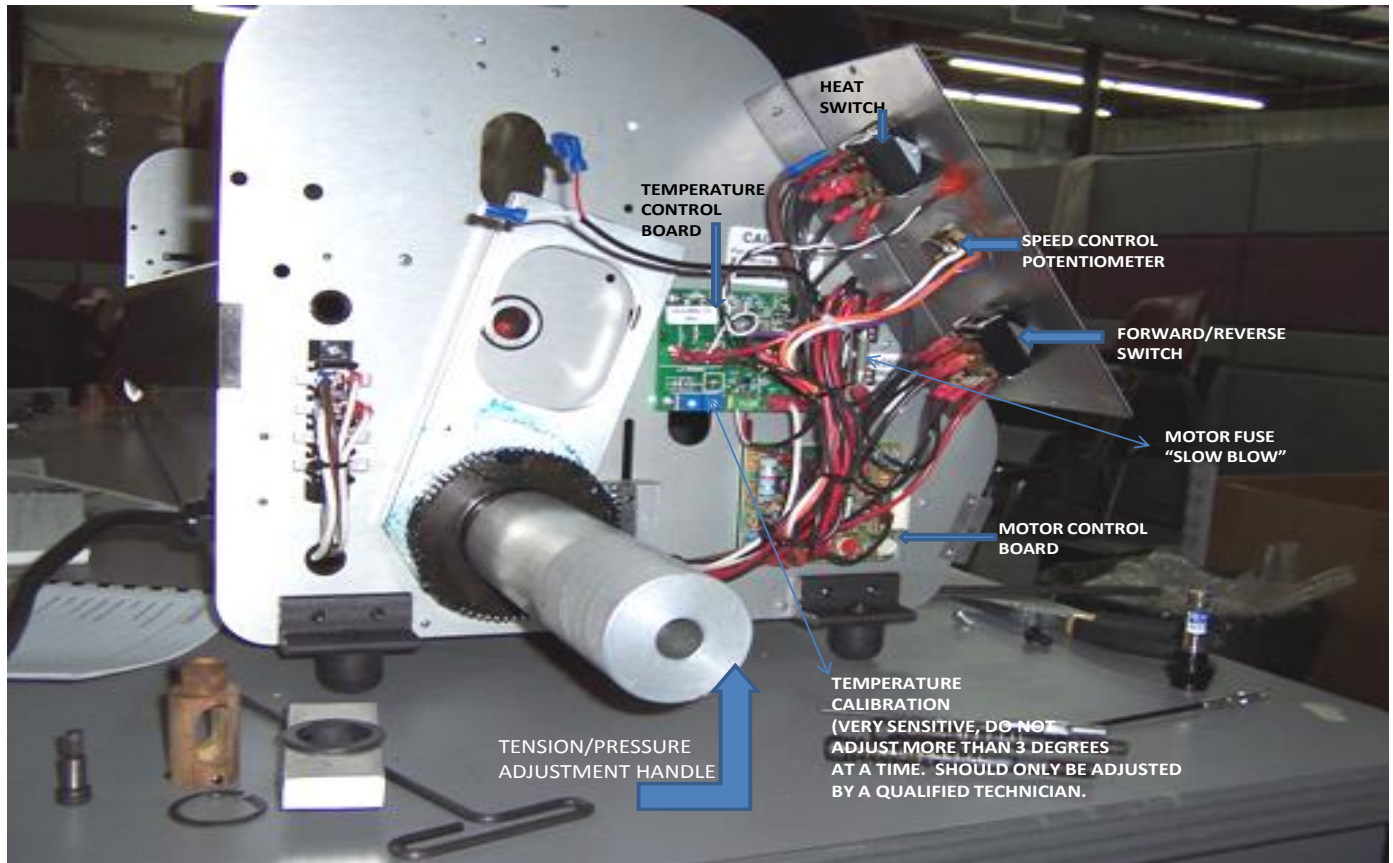
**Width – 57" (1447.8 mm)**

**Depth – 16" (406.4 mm)**

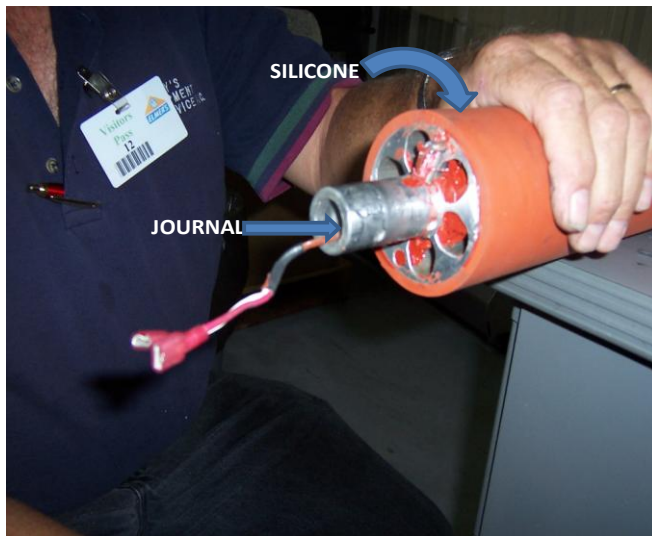
**Working capacity – 42" (1066.8 mm) by any length**



**DRIVE SIDE VIEW**



**VIEW CONTROL SIDE**



Thermal couple slides into a notch running along the journal beneath the silicone.

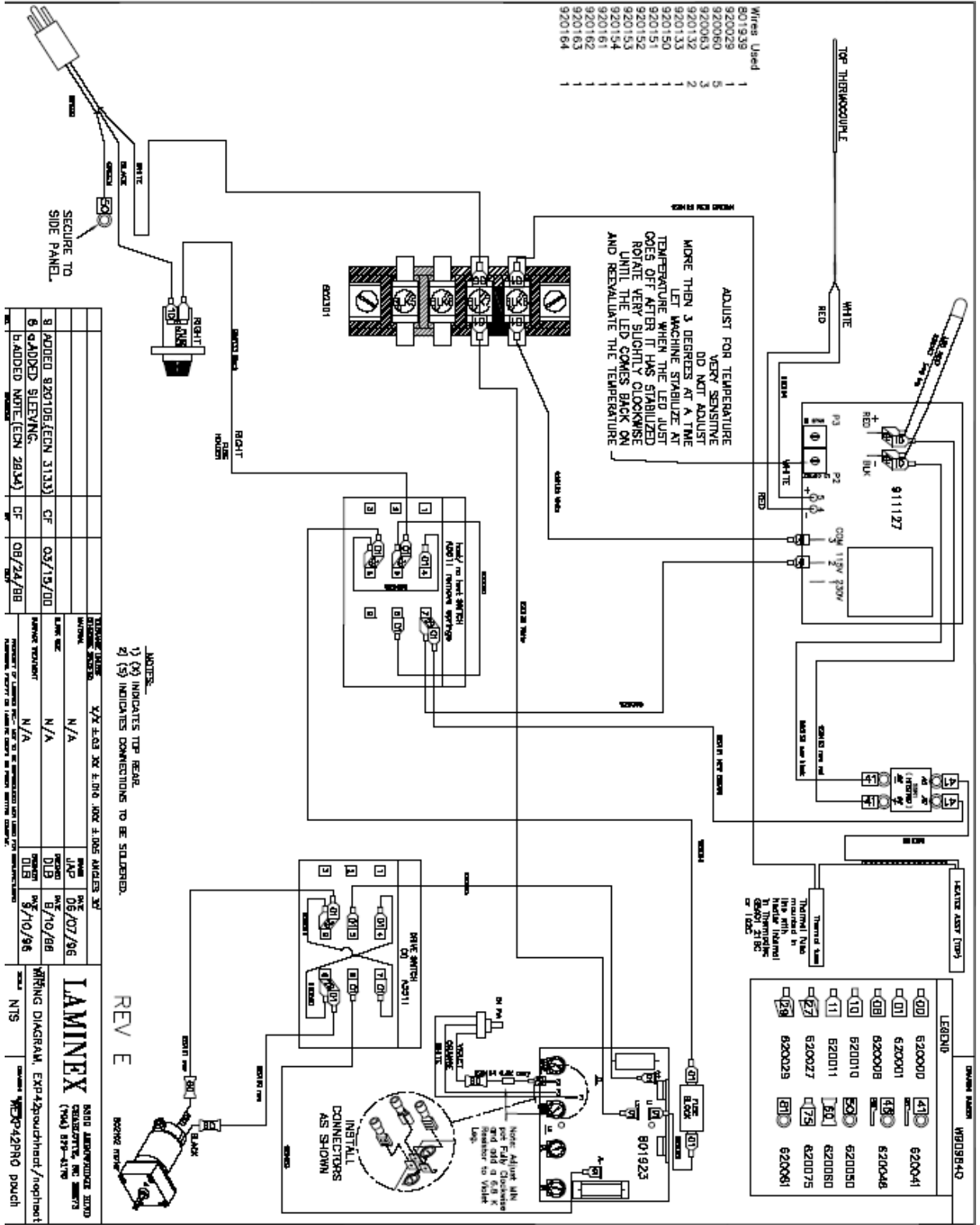
Thermal couple has the thin wires facing the control side of the machine.  
The thicker heater wires are located on the drive side.

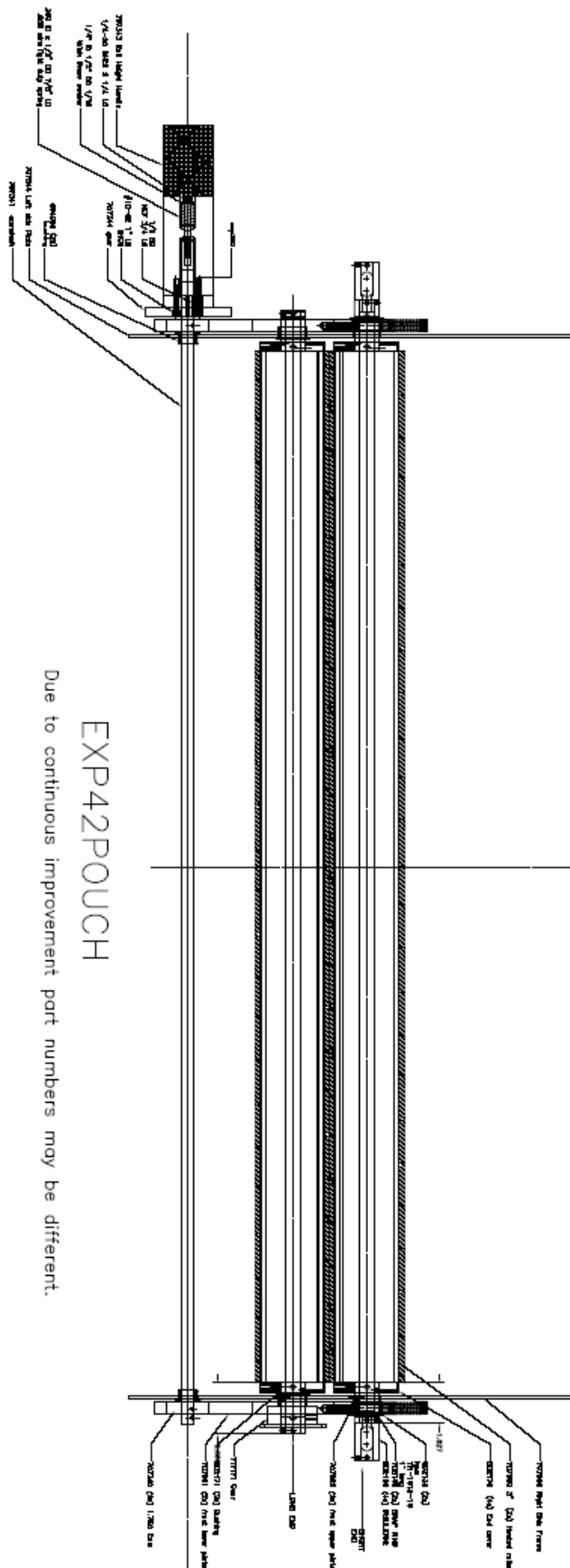
**ELECTRICAL SCHEMATICS**

**&**

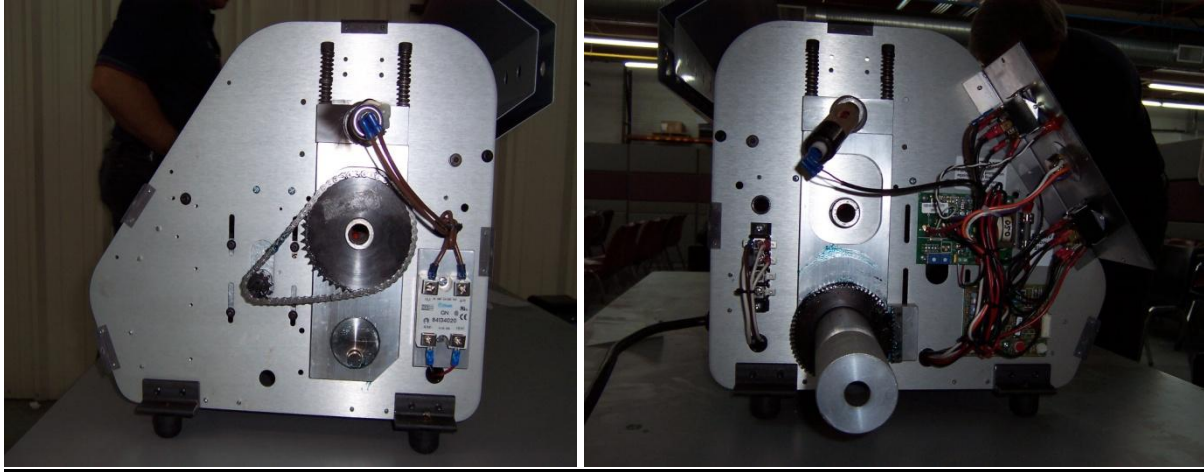
**ROLLER SCHEMATICS**

- Wires Used
- 801938 1
  - 920029 1
  - 920060 5
  - 920063 3
  - 920132 2
  - 920133 1
  - 920150 1
  - 920151 1
  - 920152 1
  - 920153 1
  - 920154 1
  - 920161 1
  - 920162 1
  - 920163 1
  - 920164 1





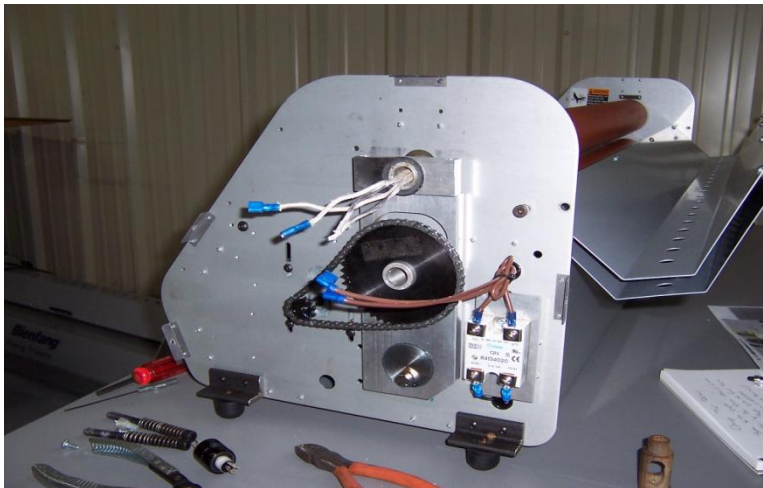
## **CHANGING TOP HEATED ROLLER**



**REMOVE BOTH SIDE CAPS**

**REMOVE STIFFENING BOARD FROM BEHIND COVER**

**REMOVE SCREWS TO BOTH SIDES OF FRONT PLATE**



**DISCONNECT HEATER WIRES FROM MERCOTAC**

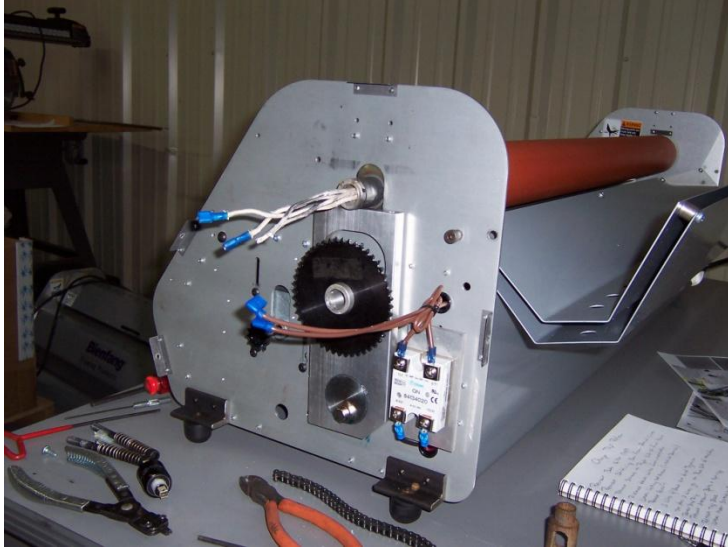
**LOOSEN LOCKING SET SCREWS (IN END OF JOURNAL)**

**REMOVE FENALIC**

**TWO WIRES WITH BLACK ARE TIED TOGETHER**

**THE OTHER TWO WIRES GO TO BACK SIDE OF MERCOTAC**





**REMOVE SNAP RING**

**REMOVE PRESSURE BOLTS AND SPRINGS (BOTH SIDES)**

**REMOVE TOP BLOCK (AKA BEARING PLATE) FROM BOTH SIDES**

**LOOSEN MOTOR SCREWS TO LOWER MOTOR AND REMOVE DRIVE CHAIN**

**DISCONNECT TOP AND BOTTOM WIRES FROM SOLID STATE RELAY**

**(TOP 2 ARE AC CONNECTIONS, BOTTOM DC, BLACK NEGATIVE, RED POSITIVE)**

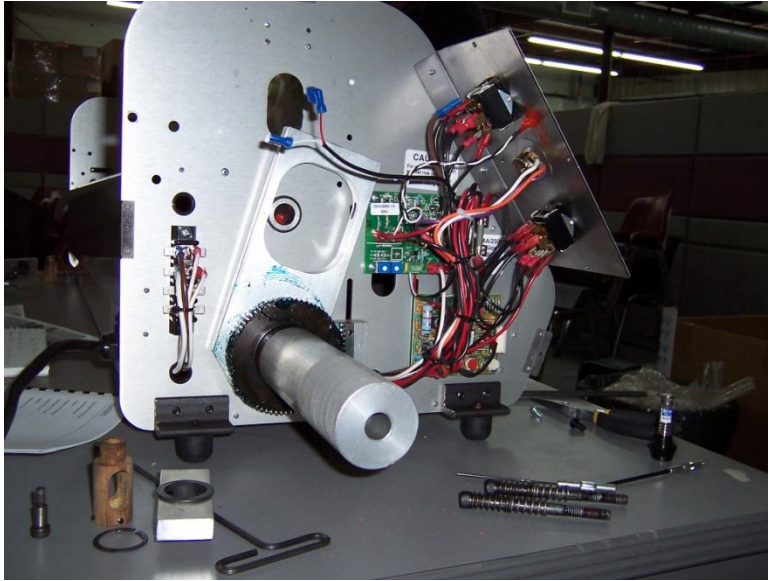
**REMOVE LARGE MAIN DRIVE GEAR**

**DISCONNECT LIFTING PLATE FROM CAM**

**REMOVE CAM**

**REMOVE HEAT SHIELD COMPLETELY**

**REMOVE BACK COVER**



**BEFORE PULLING ROLLER OUT:**

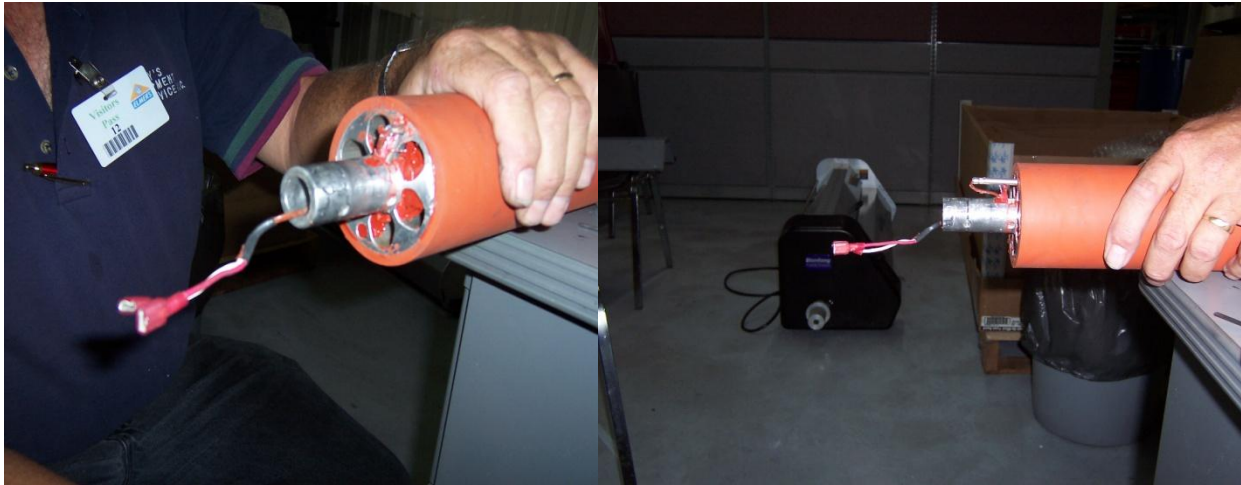
**DISCONNECT THERMAL COUPLE WIRE FROM MERCATAC**

**(RED WIRE FROM THERMAL COUPLE GOES TO MIDDLE CONNECTOR ON  
MERCATAC)**



**HEATER REMOVED**

## **PICTURES OF THERMAL COUPLE IN HEATER**



**RED AND WHITE WIRES OF THERMAL COUPLE GO TO ELECTRICAL SIDE**

**RED WIRE GOES TO CENTER CONNECTION**

**NOTE\*\***

**ON THE SHEET METAL, TIMMERMAN NUTS ARE PLACED ON BOTTOM 4 SCREWS  
AND BACK LOWER 2.**

**WHEN PRESSURE ADJUSTING BOLTS ARE REPLACED, THEY MEASURE APROX.  
1.25" FROM TOP TO BLOCK**

## TENSION HANDLE

In the event adjustments need to be made to the adjusting handle:

Remove (7) screws from left side panel. (Three shorter screws are around control area).

Loosen set screw (1/8" Allen) in thickness adjustment ring.

Slide off adjusting handle.

Slide off side panel.

With the use of a 3/16" Allen, turn inside handle shaft to disengage bolt and spring.

You can then slide off handle.

Check base to see that key way is in place. (It slides in a notch on base). If not in place it could jam and be the cause of handle not turning for adjustment. (I came across that scenario).

## **HEATER RESISTANCE**

In checking some of the units, we found the resistance to be approx. 11.3 OHMS.

While holding Mercotac, use needle nose pliers to grab hold of connector to pull wires from Mercotac to check.

## **TEMPERATURE CALIBRATION**

Top heated roller heats to approx. 315 degrees. In the event the roller is not getting hot enough, a qualified tech, may adjust for temperature.

Loosen set screw and slide off thickness adjusting indicator.

Remove control side cover.

Locate P2 on temperature control board.

This pot is very sensitive, so you do not want to adjust more than a few degrees at a time.

Let the machine stabilize at temperature and await the LED light to go off. Turn pot slightly clockwise until LED comes back on. Reevaluate temperature to see if it is within a workable range. If not, proceed in this manner until proper operating temperature is met.